

Date: Wednesday, 10/1/2008 8:00:38 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 427 "I" BEAM
Job Number	: 42366		
Estimate Number	: 10369		
P.O. Number	:	Part Number	: D2792130
This Issue	: 10/1/2008 S.O. No. :	Drawing Number	: D2792 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A1
Previous Run	: 33518	Material	:
Written By	:	Due Date	: 10/17/2008 Qty: <u>60</u> Um: Each
Checked & Approved By	: <u>JUD 08.10.01</u>		
Comment	: Est. A 98.11.09 New Issue KS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7356

- a) Extrude as per Dwg D2792
 b) Material: 6061-T6 (QQ-A-200/8)
 c) Tool: MS-19248
 d) Material certification is required.
 e) 130 is equal to 130.0"

C20810110(60)

2.0	D2792130P	EXTRUSION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 75.0000 Each(s)
 EXTRUSION

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification and pull test results attached

8/14/04 (67)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Level 6
 Check pull test Report to Dwg D2792 for compliance

8 06/01/07 (77) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 427 "I" BEAM

Job Number: 42366

Part Number: D2792130

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 008

08/10/27



[Signature]

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

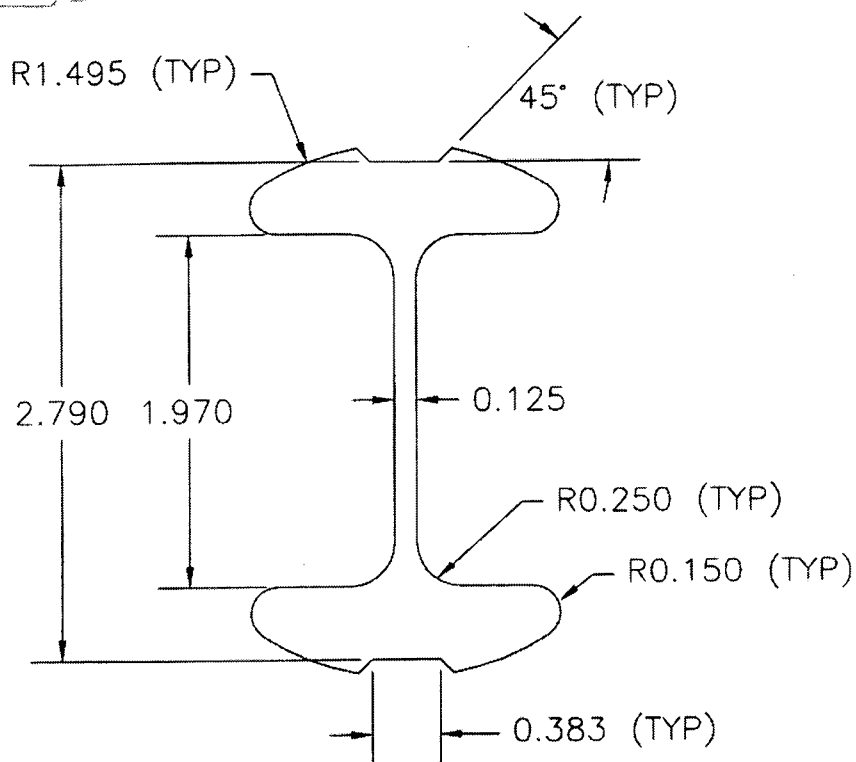
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2792	REV. A SHEET 1 OF 1
DATE 98.08.13		TITLE EXTRUSION	SCALE 1:1
A	98.08.13	NEW ISSUE	
A1	01.04.17	ADD NOTE #7 <i>[Signature]</i> (P)	

RELEASED
98 08 25 BS



GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2. MANUFACTURED USING CARADON INDALEX DIE # MS-19248
3. BREAK ALL SHARP CORNERS 0.010 MAX.
4. NO ID TOOLING MARKS.
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.

7. PART NUMBER IS D2792-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2792-145 IS 145" LONG)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42300



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**

Adresse / Address : **1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7**

Commande Indalex / Indalex order # : **8101299**

Bon de commande / Purchase order # : **7356**

Matrice / Die # : **MS 19248** Description : **N/A**

Alliage & trempage / Alloy & temper : **6061 T6**

Contrôle / Control # : **86790-1**

Coulée / Cast # : **08090461B**

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	40058
Contrainte élastique Yield stress (psi)	35 000	35055
% élongation dans 2" % elongation in 2"	8	10
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	88

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : **20-10-2008**


Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited